100

120

OC

120

Quality Control

August-03-12 2:50:03 PM Item ID: D350-567-113 Accept *N900040100* Setup Start Revision ID: Replacement Window, Extra Item Name: Start Date: 03/08/2012 Start Oty: 2.00 Cust Item ID: Required Date: 17/08/2012 Rea'd Oty: 2.00 Customer: Reference: Run Start Date: 12/08/03 Tooling: Process Plan: MLJ Approvals: Date: OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Reject Accept Insp. Description Work Center ID Oty Run Hours Code Otv Number Stamp Draw Nbr Revision Nbr IIN-D350-567 Rev D 100 habal 0.00 MUS 12-09-28 DOCUMENT CONTROL Blanc *100* 0.00 Memo Document Control Photocopy bluefile & type labels per PPPD350-567-113 CHG003 110 0.00 Packaging *110* Packaging 0.00 Memo Pick Packing Kit Packaging ***ENSURE DT 8439 TEMPLATE IS INCLUDED***

0.00

QC4-100% Inspect kits for completeness

Memo

NCD. W						WORK ORDER NON C		UFOR	AANICE / LIE	DATE		LAQA.	Date	1
NCR: Y	es / N					WORK ORDER NON-C	.Or	NFORI	VIANCE / UP	DATE	(QA Clased:	Date	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Work Orde Part N NCR N	o					DISPOSITION Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	DEP	ARTMENT/		Engineering Quality Other
Root	T		T	Desc	rip	otion of work order update		nitial	Ac	ction		Sign &		
Cause	Date	Step	Qty			r Non-conformance	Ch	ief Eng	Desc	cription 🧂		Date	Verification	QCInspector
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	Cracks					Broken/Damaged		Inspecti	on Incomplete	2 - 15	F	art meorre	t	v∀eld
1 22	_	d/Crimped	l.			Burrs		Instruct	ions Incomplete,	/Unclear	Sya F	art Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance		F	art Moved		
IS & S	Heat T	reat				Countersink		Mislabe	led	a a	F	ositioned V	Vrong	
Program	Inspec	ion Strip ir	Tube			Cut Too Short		Misread			Power Loss/Surge			Other
	Ripples	in Bend				Drill Holes		Offset		art &				

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Page 2

August-03-12 2 50:03 PM

Item ID: Revision ID: D350-567-113

Accept

N900040100

Setup Start

Item Name: Start Date:

03/08/2012

Start Qty: 2.00

Req'd Qty: 2.00

Replacement Window, Extra Large

2

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Required Date: 17/08/2012

Process Plan:

Date:

Tooling:

Date:

Start Run

Reject

Qty

Accept

Qty

OC:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Number Stamp

Insp.

Sequence ID/ Work Center ID

130

120

Packaging Packaging

Operation Description

Set Up/ Run Hours

0.00

0.00

Packaging

Memo

AD 87575 Identify and pack for shipping as per PPPD350-567-113

Location:

PPP Rev:

140

QC

140

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MLJ 12-09-28

Reject

W120928

NCR: Ye	s / No				WORK ORDER NON-C	CON	NFORM	MANCE / UPDATE	QA Closed:	Date:	
Vork Order:					DISPOSITION	1		AGAINST DE	PARTMENT/	PROCESS Water Jet	Engineering
Part No					Scrap Use-as-is Work Order Update		Therm	Machining Small Fab Finishing Large Fab Composite	A STATE OF THE PARTY OF THE PAR	Eng. Coor. e/Packaging Supplier	Quality Other
Root Cause	Date	Step	Qty	Descr	iption of work order update or Non-conformance		nitial ief Eng	Action Description	Sign & Date	Verification	QCInspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved				,							
						AUL	T CATE	GORY			
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	Cuffs Heat Trea Inspection	t n Strip in	Tube		Contamination Countersink Cut Too Short		Mainte Mislabe Misread	enance eled	Part Moved Positioned W Power Loss/S	/rong	Other
	Ripples in			.	Drill Holes	-	Offset				
	Turning S			-	Drawing	-	2000	Calibration		il in the second	

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

August-03-12 2:50:07 PM

Work-Order ID: 88811

D350-567-113

88811 *D350-567-113*

Parent Item Name: Replacement Window, Extra Large

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

Parent Item:

IPP Rev:A 04-08-24 New Issue JLM

	IPP Rev:B 08-10-	07 as per revD	DD ve	rified by:									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issaed	Status
*212-12 *212-12* Receptacles		Purchased	No			110	Each	297.0000	**	24 M12	2800		%
				Location	1	Loc	Qty	Loc Code	,				
				380			200		=				
					122452		200						
				ST380			97						
					120077		20		_				
					121827		77		-				
2600-6		Purchased	No		ţi.	110	Each	387.0000	12	24		1 1	1
2600-6									** /	112276	3	0/9/14	slo
				Location	1	Loc (Qty	Loc Code					

Location	Loc Qty	Loc Code
ST380	387	
120077	8	
121556	4	
122317	34	
122335	145	
122441	196	

Page 1

NCR:		es	/ N	10
W.R.	1	62	/ 13	10

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	2	4 (2.3	Ġ.
	THE PERSON NAMED IN			

	ACCESS ON MANUAL	AND READ	Transition of	LEGIL TV					QA Closed:	Date:	
Work Orde	or:			Live St.	DISPOSITION	HE VENIE	1	AGAINST DEF	PARTIMENT	PROCESS	
Part N				=//I	Rework Scrap Use-as-is		Machining S	Finishing		Water Jet J. Eng. Coor.	Engireering Quality Other
NCR N	lo				Work Order Update			omposite		Supplier	
Root				Descri	ption of work order update	Initial	Action	1 194	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descriptio	on	Date	Verification	QCInspector
Doc/Data Equip/Tooling Operator				ja-s							
Material		1		3 5				1 1			
Setup								1			
Other								19			
Process								F			
Supplier	_					-		100			
Training Unapproved		1									100
Oliappioved		.1				AULT CATE	GORY	127	dich	30 mil	
Landi	ng Gear				General	HOLI CHIL	JON.			New	
	Bending	Į.		Г	Bend	Grain			Ovalized		Pressure/Forced
		Not Conce	ntric to	o/s	BOM/Route	Hardwa	ire	24 157	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete	100	Part ncorre		₩eld
	Crushed	/Crimped			Burrs		tions Incomplete/Uncle	ear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat Tre	eat			Countersink	Mislabe	led	7	Positioned V	Vrong	
	Inspecti	on Strip in	Tupe		Cut Too Short	Misread	ii.	1 1	PowerLoss/	Surge	Other
	Ripples	in Bend			Drill Holes	Offset		The state of the s		1.0	
	Torque	Waves in I	Extrusio	n _	Drawing	Out of (Calibration				1 3 4
	Turning	Sequence			Finish	Out of 5	Sequence			37	
	Wave/T	wist in Tu	be		Folio	Outside	Dimensions				

Picklist Print

August-03-12 2:50:07 PM

Work Order ID: 88811

88811

No

Parent Item:

D350-567-113

D350-567-113

Parent Item Name: Replacement Window, Extra Large

Purchased

Purchased

Start Date: 03/08/2012

Required Date: 17/08/2012

Required Qty: 2.00

Start Qty: 2.00

511.0000

2600-LW

Location	Lo	c Qtv	Loc Code
380		196	
122452		196	
ST380		312	
121524		112	
122317		200	
ST381		1	
121287		Ĭ.	
ST398		2	
120648		2	
	110	Each	382.0000

110

Each

82.0000



6C832R9* Screw

Locatio	<u>n</u>	Lo	e Qty	Loc Code	
ST346			373		
	120181		21		
	121556		152		
	122151_		200		
ST347			9		
	118983		9		
		110	Each	0.0000	4.

AN960JD8

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No

No

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84

M122441 12/9/prf

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WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	

									QA Closed:	Date:	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part N	lo			=	Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty		ption of work order update or Non-conformance	Initial		Action	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator	Date	эсер	Qty		or Non-conformance Chief Eng Description				Obte		Ce mapector
Material Setup Other Process											
Supplier Training Unapproved				1							
						AULT CAT	EGORY				
Landir	Bending Centre N	ot Conce	ntric to	o/s	General Bend BOM/Route	Grain Hardw			Ovalized Over/Under		Pressure/Forced Temperature/Cure
, agame	Cracks Crushed/ Cuffs	Crimped			Broken/Damaged Burrs Contamination	Instruc	tion Incomplete		Part In:corre Part Lost/M Part Moved	_	Weld Wrong Stock Pulled
Assets 1	Heat Treat Inspection Strip in Tube				Countersink Cut Too Short	Mislat	Maintenance Mislabeled Misread			Vrong Surge	Other
	Ripples in Bend Torque Waves in Extrusion				Drill Holes Drawing		Calibration				
en e	Turning S				Finish		Sequence le Dimensions				du Tal

Picklist Print

August-03-12 2:50:07 PM

Work Order ID: 88811	*88811*				
Parent Item: D350-567-113		10+			
Parent Item Name: Replacement Window, Extra Large	*D350-567-11	1.3^		3.00/2012	
ratent tem traine. Replacement window, Extra Large			Start Date: 0	AND DOWNSON STATES STATES STATES STATES	Date: 17/08/2012
			Start Qty: 2	Require	d Qty: 2.00
D2463 Manufactured	No	1i0 f	474.9074 7.166	15.08632	-10
D2463			**		84
Seal				0	
	Location	Loc Qty	Loc Code		
	ST404	474.90737			
P	72232	15.38			
report shift	79478	0.43737			-
2 ENOT!	83542	459.09			
1x (132463-9860 as per dwg) CUT TO 86.00"					\wedge
D3290-041 Manufactured	No	IIO Each	5,0000	2	
D3290-041			**	B85951 S	C-1
Replacement Window Assembly				(202/20	11
	Location	Loc Qty	Loc Code	Banco	72/ 12/01/2
	ST213	1	**************************************	- 80 O	100 19111
	82838	Î			Sul 00
	ST218	3			Rap
	73721	2			
	79360	1			
	ST219	Ĩ			
	79360	1			
FG-778150-550-ROL Purchased	No	110 sf	2,764,491 18	36 . 1	
FG-778150-550-ROL			**	in hola de	2
7781 9oz Glass 50"x125yd				QH11350	8
7761 902 Class 30 X123yd	Location	1 0	1 6 1		
		Loc Qty	Loc Code		
	CA	2764.491		s 	
	104845 108932	3 18			
	111166	392			
	113905	564			
	117602	664.651			
	119099	1122.84		30	
2sq yards	-				

NCR: Y	es	/ No					WORK ORDER NON-C	01	NFORM	MANCE / UPDATE	QA Closed:	Date:				
Nork Orde	۳.						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	0.						Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Crosstube Small Fab Finishing Composite		Water Jet I. Eng. Coor. e/Packaging Supplier	Engineering Quality Other			
Root					Desc		tion of work order update		nitial	Action	Sign &					
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description	Date	Verification	QC Inspector			
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100		Bending					Bend		Grain		Ovalized		Pressure/Forced			
		Centre No	t Concer	ntric to	0/5		BOM/Route		Hardwa	ire 💮 💮	Over/Under	tolerance	Temperature/Cure			
		Cracks					Broken/Damaged		Inspecti	ion Incomplete	Part Incorred	t e	Weld			
		Crushed/C	Crimped.				Burrs		Instruct	ions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs					Contamination		Mainte	ALC: USA	Part Moved					
De la la	- 10	Heat Treat	t				Countersink		Mislabe		Positioned V	-				
	-11	Inspection		Tube			Cut Too Short		Misread	d Adv La	Power Loss/	Surge	Other			
		Ripples in					Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n		Drawing		Out of (Calibration			Marie English			
	Turning Sequence Finish			Finish		Out of	Sequence		# # # # # # # # # # # # # # # # # # #							

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

'Picklist Print

Parent Item:

*August-03-12 2:50:07 PM

Work Order ID: 88811

D350-567-113

Parent Item Name: Replacement Window, Extra Large

88811

No

D350-567-113

Start Date: 03/08/2012

Required Date: 17/08/2012

Start Qty: 2.00

Required Qty: 2.00

12,044,00

MS20426AD3-5 *MS20426AD3-5*

MS21042L08

Location Loc Qty ST316 12044 4179 390 4444 5558 4533 6096 110 Each

110

Loc Code

1.301.000

Purchased

Purchased No

Fach

Location Loc Qty 315 500 122452 500 ST300 121524 ST317 800 122141 800 Loc Code

NCR:	Yes /	No

WORK ORDER NON-CONFORMANCE / UPDATE

		10
DQA:	Date:	1
		•

				31:1						QA Closed	: Date	:
Work Orde	ır.				DISPOSITION				AGAINST	DEPARTMEN	T/PROCESS	
WOIK Olde					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pr	od. Eng. Coor.	Quality
					Use-as-is	1	Therm	oforming	Finishing	Rec/St	ore/Packaging	Other
NCR N	lo.				Work Order Update		1	Large Fab	Composite		Supplier	17 - 17 - 17 - 17 - 17 - 17 - 17 - 17 -
3-1			, ,		112				- And -			The second
Root					ption of work order update	(0,000)	itial		tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector
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quip/Tooling												
perator												
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Process											第1 章	
Supplier						1			1.4	U B t		The state of the s
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Landir	ng Gear				General				. F F.			
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (0/5	BOM/Route	H	ardwar	re	7.3	Over/Und	er tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ir	nspectio	on Incomplete		Part Incom	ect	Weld
	Crushed/	Crimped			Burrs			ons Incomplete	/Unclear	Part Lost/	_	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance	- 4	Part Move		
	Heat Trea				Countersink	\vdash	Mislabel		38	Positioned		
	Inspectio		Tube		Cut Too Short	\vdash	Misread		填	Power Los	s/Surge	Other
	Ripples in		- 19		Drill Holes	Offs		V 200 - VC -	9	A 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		
A. S. C.	Torque V			n	Drawing			alibration		1 00		
	Turning S				Finish			equence				
100	Wave/Tv	vist in Tul	be		Folio		Outside	Dimensions				

PARTS LIST 5.0

Qty -015	Qty -017	Qty -025	-027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	Х					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
	-	-		1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty	Qty	Qty	Qty	Qty	Ded Number	Description
-013	-023	-113	-115	-031	Part Number	REPLACEMENT WINDOW KIT (SMALL)
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALE)
	X				D350-567-023	REPLACEMENT WINDOW KIT (DARGE)
		X			D350-567-113	INTERIOR FLOOR WINDOW KIT
			X		D350-567-115	
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
			-			
1					D2125	REPLACEMENT WINDOW, SMALL
	1			2500	D2942	REPLACEMENT WINDOW, LARGE
		1	-		D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1		-		_	D2126-0600	SEAL
-	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12	200		2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21	- L.		MS21042L08	NUT (OR MS21042-08)
	18	24	Walder !		MS20426AD3-5	RIVET
2 SQ.	2 SQ.	2 SQ.			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
YD	YD	YD			1	Constitution of the Consti
				1	D2463-0450	NEOPRENE SEAL
		1	-	1	D3210-1	DOUBLER
			-	1	D3210-1	BRACKET
			-	1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1	-	D3293-1	DOUBLER
			1		D3294-1	BRACKET
	-	-	1		D3295-041	FLOOR WINDOW
		<u> </u>	1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		-	9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
	-		9	8	AN960JD6	WASHER
		-	9	8	MS21042L06	NUT (OR MS21042-06)
-	-	-	2	40	MS20470AD4-5	RIVET
		-	115	90	MS20470AD4-6	RIVET
		-	15	20	MS20470AD4-7	RIVET

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Revision: D

Date: 08.07.08